

Date: Thursday, 15/01/2009 11:24:26 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDE BAR
Job Number	: 44842		
Estimate Number	: 11085		
P.O. Number	:	Part Number	: D30111
This Issue	: 15/01/2009 S.O. No. :	Drawing Number	: D3011.REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 40938	Material	:
Written By	:	Due Date	: 30/01/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JLD 09-01-15</u>		
Comment	: Est. C ~ 02.05.09 Added D6202 at step 2 NG Est Rev:D Added QC8 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6202	I-Beam Extrusion
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Comment: Qty.: 1.0000 f(s)/Unit Total : 6.0000 f(s)

I Beam Extrusion

Material: 6061-T6 (QQ-A-200/8)

"I" Beam Extrusion 4" x 2.796" x 0.326"

Batch 37669

H.A 09/01/19

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks: 26.57"

H.A 09/01/19

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Ensure Batch Number programmed matches this W/O

Machine as per folio FA129

JL/H.A 09/01/19
 PTO →

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/01/20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

28 09/01/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3011-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 18 Date: 09.01.29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12 Date: 09/02/02

NCR: <u>44842</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/19	3.0	1 part scrap due to wrong jaw with different dimension R.C. Incorrect tooling.	<i>[Signature]</i>	The 4 jaw have been machined at the same thickness and will be identified to make sure it won't happen again	H.A 09/01/19	<i>[Signature]</i> 09.01.21	<i>[Signature]</i>	<i>[Signature]</i>
09/01/20	3.0	1 part scrapped lifted while machining: vibrated dimension 1.250 is under tolerance by 0.010"	<i>[Signature]</i>	= scrap + replace only 1 <u>B37669</u>	J.L 09/01/20	<i>[Signature]</i> 09.01.21	<i>[Signature]</i>	<i>[Signature]</i>
		R.C. Previous set up by another shift had set up with different tool offsets, and when the 2nd side was machined, tools were run at zero offset. This resulted in a gap above the spacers causing lift & vibration.	<i>[Signature]</i>					

NOTE: Date & initial all entries ~~to~~ Set-up error.

Date: Thursday, 15/01/2009 11:24:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDE BAR

Job Number: 44842

Part Number: D30111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 9-1-23



x6

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



m 109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:30

OVEN TEMPERATURE:

320°

FINISH TIME:

9:00

FL 09/01/26

6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

G.m 09.01.26 6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST137

JS 09/01/27 6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/27 6

Job Completion



h 09.01.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44842
Description: Cappel slide bar		Part Number: D3011-1
Inspection Dwg: D3011	Rev: A	Page 1 of 1

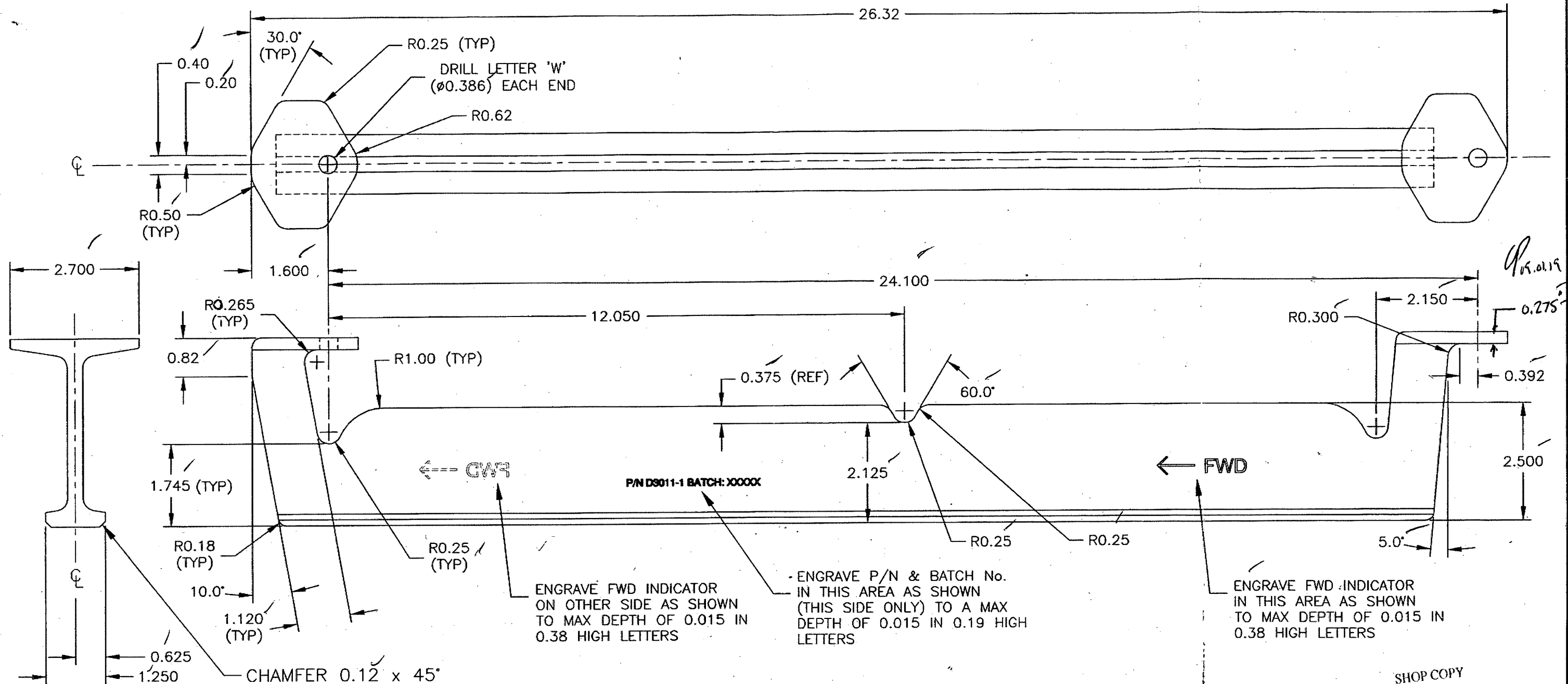
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.700	$\pm .010$	2.702	✓			
1.250	$\pm .010$	1.251	✓			
.625	$\pm .010$.623	✓			
.120x45°	$\pm .010 \pm .5^\circ$.125x45°	✓			
Ø.386	$\pm .005$ $\pm .001$.386	✓			
1.600	$\pm .010$	1.600	✓			
26.32	$\pm .030$	26.32	✓			
1.50	$\pm .030$	1.500	✓			
30°	$\pm .5^\circ$	30°	✓			
.275	$\pm .010$.275	✓			
2.500	$\pm .010$	2.505	✓			
5°	$\pm .5^\circ$	5°	✓			
24.100	$\pm .010$	24.100	✓			
2.125	$\pm .010$	2.124	✓			
1.25	$\pm .030$	1.250	✓			
.375	$\pm .010$.375	✓			
1.120	$\pm .010$	1.120	✓			
1.745	$\pm .010$	1.753	✓			
.82	$\pm .030$.823	✓			
10°	$\pm .5^\circ$	10°	✓			

Measured by: J.L.	Audited by: J.S.	Prototype Approval:	N/A
Date: 09/01/20	Date: 07/01/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



RELEASED
01.04.09



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41842

D3011-1
MANUFACTURE FROM D6202-027 EXTRUSION
BREAK ALL SHARP EDGES 0.010-0.020
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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A	01.03.29	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	1	DRAWING NO. D3011
DATE	01.03.29	TITLE RAPPEL SLIDE BAR
		REV. A SHEET 1 OF 1 SCALE 1:2

